

CG 03 CODE KY-788-D PKG

PROCESSES

APPROVED BY

LOT DEC-2 80 38093

() KY-788-D (J) FWP 11/3/80

EST'D WGT 940 LBS

() 4 HOUR STRIKE

() AS FOR XOB-17

STANDARD HRS. B.B TIME M

TYPED BY: FP 11/3/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS
14	YC003B	13071	93	2000
14	YC003B	13066	93	600
14	YC003B		93	

CG	CODE	LOT	PQ	LBS
14	YC003B		93	
14	YC003B		93	
14	YC003B		93	

TOTAL EST'D WGT 3560

CLEAN UP
AS YOU GO ALONG

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-LIGHT	USE LBS	N- CODE	ACCT LBS
203 & 205	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.	350		350
	2 WEIGH IN DRUM & POUR IN	345	983-D	345
	3 DUMP IN AND STIR 5 MIN	52X50	YC-3-B	2600
	RECORD: START <u>8:01</u> LOT <u>13071</u>	2000		
	FIN <u>9:43 PM</u> <u>13066</u>	600		
1	ADJUST TO 75" (1275 G)			
5	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
7	WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN. OF HOT WATER AT 2400-2600 PSI INTO V-205			
7	RECORD: V-205 VOL <u>4.4</u> & ADJ TO 60" (2100 G)			
8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V-244 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START <u>1:00 PM</u> TOTAL MINUTES <u>95</u>			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
11	WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
SP & CP	12 SP STEP 01 - SET FORMULA SELECTOR TO POSITION 3 (V-243) OR POSITION <u>8</u> (V-244)			
	13 PRESS SV CAM RESET PB - SET 22 TO IN AUTO			
	REMOTE (TEMP IS SET AT 190-194°F)			
3	14 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	15 <u>32</u> % PRESET #2 208 GAL		15-A	416
	<u>32</u> % PRESET #3 135 GAL		20-A	135
15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.34 GPM		27-D	180
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 2.8 GPM			
	3FR10 (N-27-D/WATER) RATIO 0.8			
	3FC10 (N-32-D CONTROLLER) IN MANUAL 0.45 GPM		983-D	1215
	3FC20 (N-32-D WATER) IN MANUAL LOCAL 2.5 GPM			1240
	3FR10 (N-32-D/WATER) IN REMOTE 1.1			

EQUIP

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CG 03

KY-788-D

EST WGT 3560#

USE

N-

USE

LBS

CODE

LBS

V-244

320	16	OPERATOR STEP PB			
SV	17	RECORD LEVEL 2LG 89% IF <35% FOLLOW SOLUTION			
SP	18	MAKE-UP PROCEDURE FOR N-27-D			
CP	19	ADJUST SV TO 47" (2400 G)			
	19	RECORD PH 10.0. ADJ TO 11.0-11.2 WITH N-7-D AT			
		5% (10 PARTS WATER TO 1 PART N-7-D)			
		SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50%	30	7-D	15
	20	OPERATOR STEP PB			

SV	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.7			
SP	22	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	23	OPERATOR STEP PB			
	24	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS			
		ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
5	25	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN			
		LIMITS, SWITCH 3FC20 TO REMOTE			
	26	OPERATOR STEP PB			
	27	DURING STRIKE RECORD:			
		SP STEP			
		V-243/V-244			

7:30 P.M.

PH	RANGE	TIME
13/46	9.3-10.0	8:00 P.M.
14/47	9.3-10.0	8:30 P.M.
15/48	9.3-10.0	9:30 P.M.
16/49	9.3-10.0	10:30 P.M.
16/49	9.3-10.0	11:30 P.M.
17/50	7.5-8.5	12:15 A.

INCREASED N-82 SETTING TO 0.49

NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE IN LOG. IF FINAL PH >8.5, ADJ TO 7.5-8.5. & RECORD: PH ____ ASSUME 77%

27-D

339	28	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339			
	29	ADD IN 7-8 MIN	350	530-A	350
6	30	ADJ TO 49" (382 G) AT 80-100%F			
	31	STIR 5 MIN & RECORD: PH 9.9 (9.5-10.5)			
	32	STIR 15 MIN OR LONGER FOR SP STEP 26/56			
	33	RECORD: VOL 49" & CALC 49" X 0.78 = 38.2 GAL			
	34	SET PRESET #8 TO 38.2 GAL FROM S 33			

302	35	RUN 40" (440 G) WATER INTO V-302			
7	36	ADD & STIR 2 MIN FOR S 40 ASSUME 50%	360	7-D	180

SV	37	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
	38	SIFT IN	100	128-A	100
SP	39	SP STEP 23/53. RECORD: PH 3.4 (3.7-4.2)			
	40	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5 MIN			
8	41	RECORD: PH 9.5 (9.0-9.5). ADJ IF NECESSARY & RECORD: PH ____ ASSUME 77%		27-D	
		(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%		7-D	
		(SIPHON N-7-D INTO SV)			
	42	OPERATOR STEP PB			
	43	SP STEP 29. RECORD: PH 9.5 & TIME 1:30 AM			
	44	OPERATOR STEP PB			
	45	SP STEP 60. BATCH COMPLETE.			

START TIME SP STEP

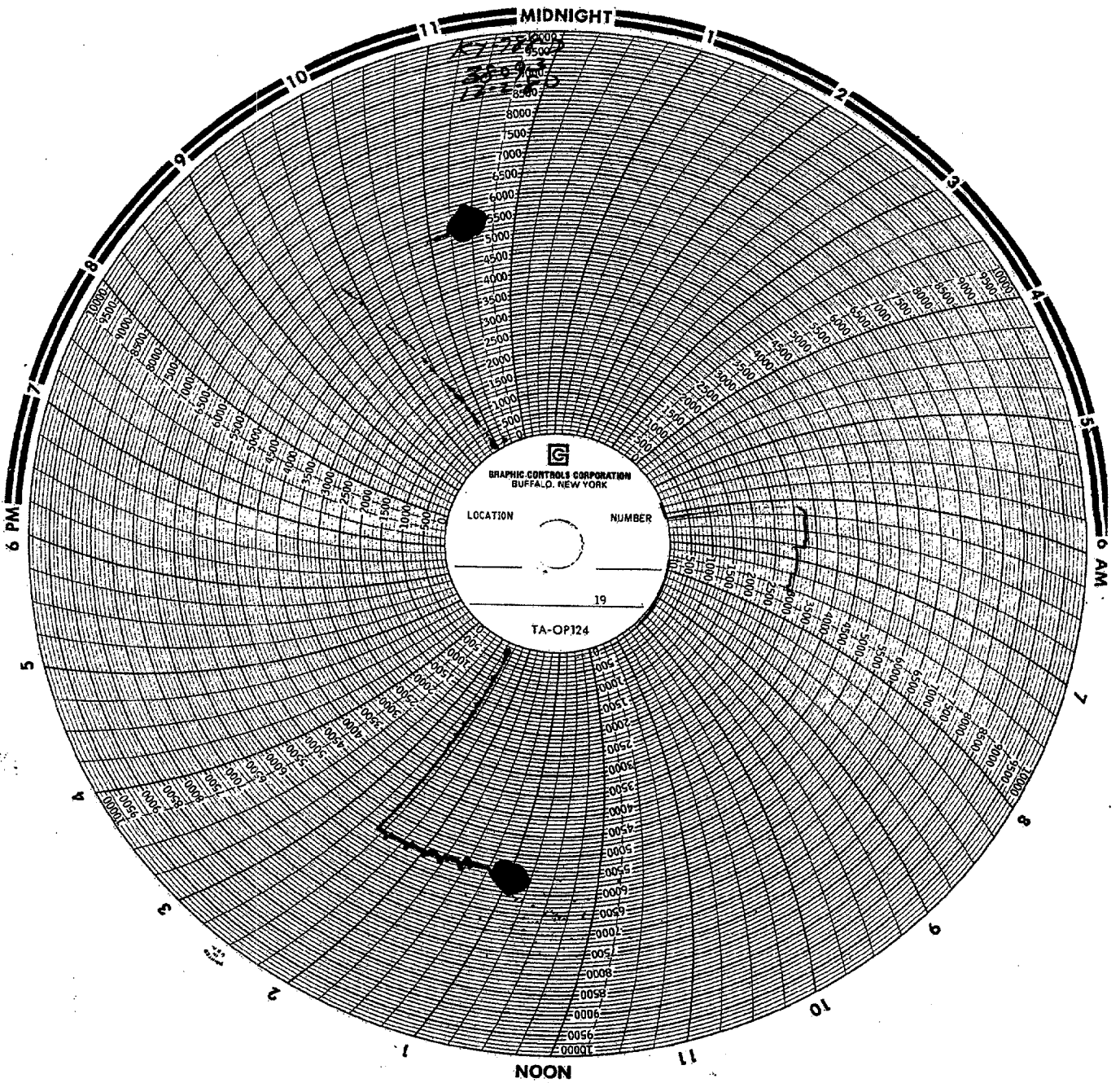
6:15 A
7:00 AM
4:00 PM
11:00 PM

FINISH TIME SP STEP

7:00 AM
3:00 PM
11:00 PM
1:30 AM

OPTR

126
44-235
381-282
301



V-244

